



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2580-1

Job Sheet 177628



Part No: D2580-1

Job Qty: 4 ea

Part Name: 205 Bent Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/15/18

Job Tracking No:

Due Date: 5/25/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD ver:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/25/18	0.00	0.00	Start Up Skidtubes		
100	Skidtubes	4 pcs		5/25/18	0.00	3.70	Skidtubes		
101	QC	4 pcs		5/25/18	0.00	0.00	QC5		
110	HandFinish	4 pcs		5/25/18	0.00	1.67	HandFinish1		
120	QC	4 pcs		5/25/18	0.00	0.00	QC7		
125	Skidtubes	4 pcs		5/25/18	0.00	3.70	Skidtubes		
130	QC	4 pcs		5/25/18	0.00	0.00	QC5		
140	Packaging	4 pcs		5/25/18	0.00	0.00	Packaging3		
150	QC21-SA	4 Ea		5/25/18	0.00	0.00	QC21		

Part Op 100 - 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D. 3-Open holes to 0.508" Descriptions: as per Dwg D2580 4-Deburr holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit inspection saddles on FWD & AFT saddle holes using DT9916.
125 - 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: M138874 Sikaflex expire date: DEC 18 Start time and date: _____ bond for 12hrs
140 - LOCATION : LG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n -I' Beam Tube 4"	4 Ea (1 ea)	90-Start up Operation	5081201
D2596	Web, 205 Skidtube	4 Ea (1 ea)	125-Skidtubes	1x675501 3x 5072212

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	4	49	0
125-Skidtubes	D2596	4	12	0

Part Specifications

Specifications could not be found.



Container No: S082300



Part: D2580-1

Job No: 177628

Serial No/Batch: S082300

Revision: H

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/19/18

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 177628
MAY 15 2018

GENERAL NOTES:

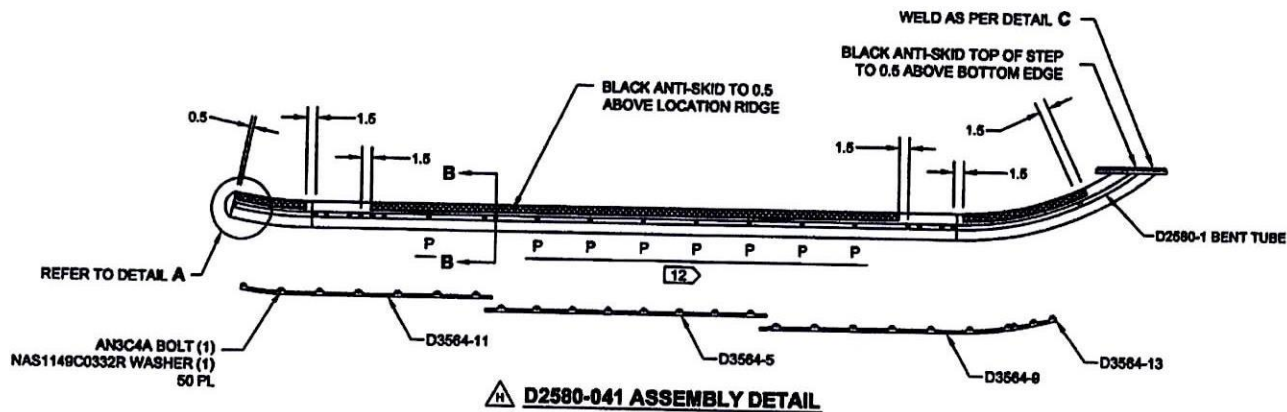
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2598 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2598 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8837 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (80 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2585 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

H	SHEET: PL DELETE D3566-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DS1 8898	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART12-218	DC	13.08.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8837 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO 88 WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	06.08.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
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APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	17.06.09		
DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA DRAWING NO. D2580 TITLE 205 SKIDTUBE ASSEMBLY REV. H SHEET 1 OF 9 SCALE NTS COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED TO THE CUSTOMER UNDER THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			

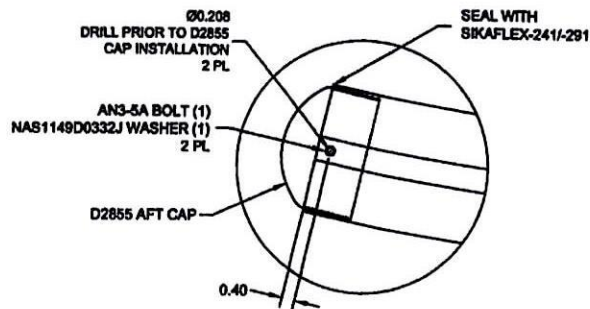
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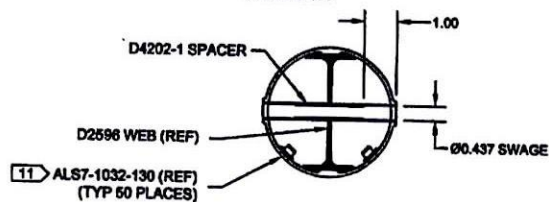
ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2585	AFT CAP
28	1	1			D3564-5	WEARSHOE
29	1	1			D3564-9	WEARSHOE
30	1	1			D3564-11	WEARSHOE
31	1	1			D3564-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5081-1	FWD WEARPLATE
36				1	D6061-3	AFT WEARPLATE
60	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
61	50	50			AN3C4A	BOLT
62	2	2	2	2	AN3-5A	BOLT
63			8	8	AN4-45A	BOLT
64	50	50			NAS1149C0332R	WASHER (AN860C10L)
65	2	2	2	2	NAS1149D0332J	WASHER (AN860JD10L)
66			8	8	MS21042-4	NUT (OR MS21042L4)



DETAIL A
SCALE 5X

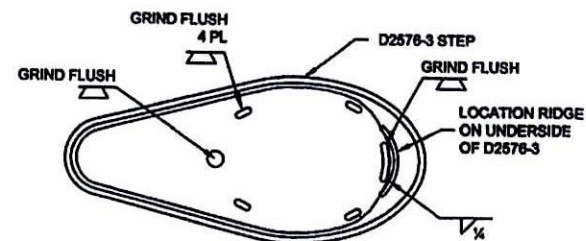


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

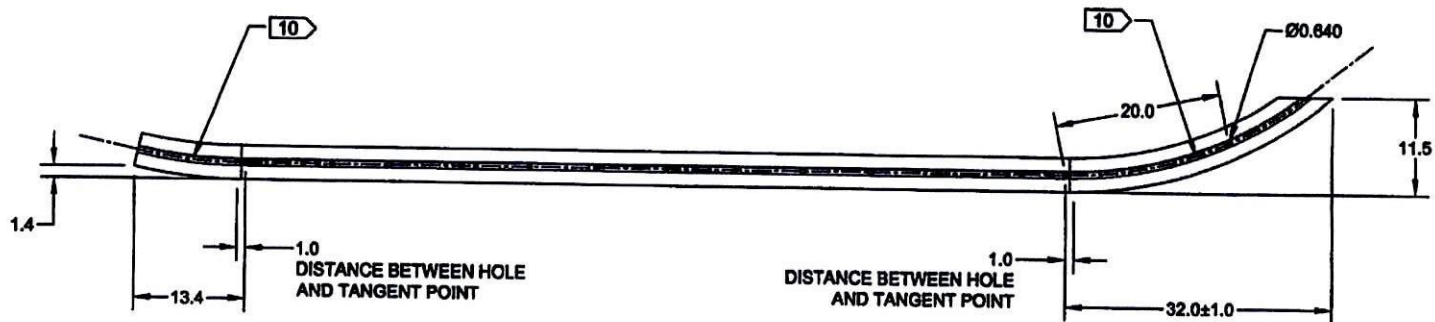
DETAIL C
SCALE 5X



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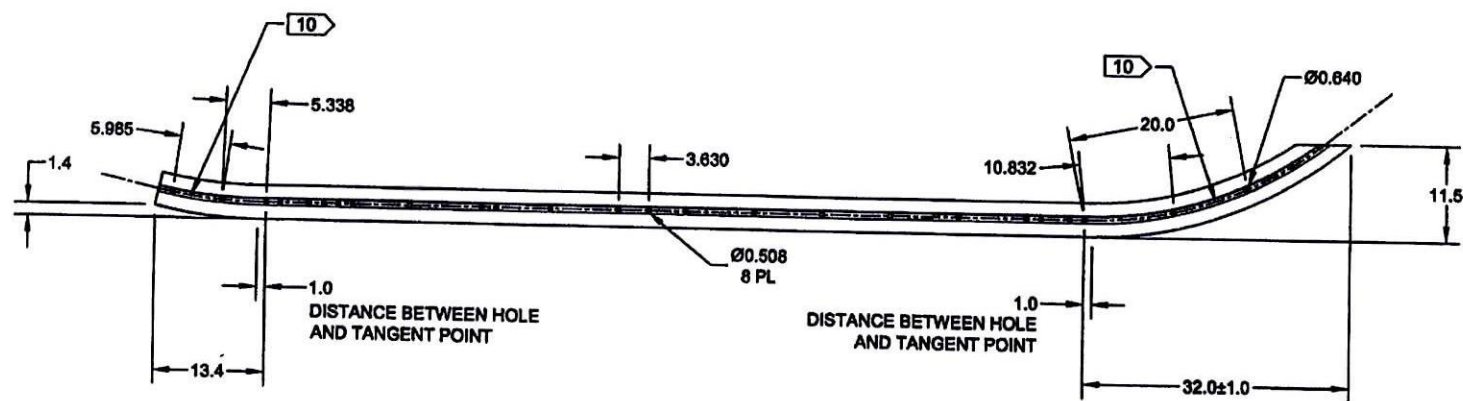
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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